

Work Order ID 73984-1

Tuesday, September 20, 2011 10:24:16 AM



Page 1

Item ID: D206-628-024

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 9/20/2011 Start Qty: 500

Required Date: 10/4/2011 Req'd Qty: 5.00



Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

MF

Date: 11-09-20

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

N/A

Rev N/A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels as per PPP D206-628-024 CHG 003

S 11/09/30

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

P

S 11-09-22

120

QC4- 100% Inspect kits for completeness

0.00



QC

Memo

0.00

Quality Control

S 11/09/30

(H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 73984

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Page 2

Item ID: D206-628-024

Accept



Setup Start



Revision ID:

Stop



Item Name: Heli-Access-Step RH

Start Date: 9/20/2011 Start Qty: 5.00



Cust Item ID:

Required Date: 10/4/2011 Req'd Qty: 5.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

0.00



Packaging

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-628-024

Location: _____

PPP Rev: _____

G

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

*10/5/30 C**11/9/30**mf 11-09-20*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

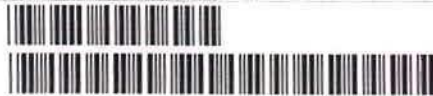
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Page 1

Work Order ID: 73984

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH



Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 5.00

Required Qty: 5.00

Comments: IPP Rev:D As Per Ecn 766 06-01-06 JLM
 IPP Rev:E as per ecn 1118 08-02-05 DD verified by:EC
 IPP rev F ncr 09-004 09.01.09 EC verified by:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN3C4A 		Purchased	No			120	Each	2,700.000	3	15			
BOLT													

Location

Loc Qty

Loc Code

ST350

2700

117313

2

117688

5

117872

22

118112

16

118451

969

118628

186

118706

500

118838

1000

15x

AN4C14A



Bolt

Purchased

No

120

Each

138.0000

4

20

Location

Loc Qty

Loc Code

ST358

138

118706

138

AN4C15A



Bolt

Purchased

No

120

Each

185.0000

8

40

Location

Loc Qty

Loc Code

ST358

185

115835

2

117795

33

118628

50

118706

100

17x
23x

Sp 11-09-29.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Page 2

Work Order ID: 73984

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 5.00

Required Qty: 5.00

AN960C416L *WASHER* Purchased

No

120

Each

0.0000

24

120

WASHER

D2731-7

Manufactured

No

120

Each

76.0000

4

20

Mounting Lug

Location

Loc Qty

Loc Code

ST468A

50

71860

50

ST470

26

62929

2

66427

24

D2732

Manufactured

No

120

f

521.8981

2

10

Rubber Extrusion

Location

Loc Qty

Loc Code

ST410

521.89811

64283

23.02811

70987

498.87

(D2732-030) Cut (8) at 3.00"

D2842-042

Manufactured

No

120

Each

0.0000

1

5

Step Assembly RH, 206 Float

D2844-1

Manufactured

No

120

Each

9.0000

2

10

Arm

Location

Loc Qty

Loc Code

ST263

9

70541

1

73328

8

Tuesday, September 20, 2011 10:24:13 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 3

Work Order ID: 73984

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 5.00

Required Qty: 5.00

D2844-3

Manufactured No

120 Each

4.0000

1 5



Arm

Location

Loc Qty

Loc Code

ST266

4

66822

4

D3394-043

Manufactured No

120 Each

49.0000

4 20



Lug Assembly

Location

Loc Qty

Loc Code

ST475

49

62930

2

62976

14

66429

33

MS21043-4

Purchased No

120 Each

1,103.000

12 60



Nut

Location

Loc Qty

Loc Code

FG

40

104603

40

ST301

1063

117793

470

118378

93

118686

500

NAS1149C0363R

Purchased No

120 Each

4,027.000

3 15



Washer

Location

Loc Qty

Loc Code

ST297

4027

114742

4027

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Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Picklist Print

Tuesday, September 20, 2011 10:24:13 AM

Page 4

Work Order ID: 73984

Parent Item: D206-628-024

Parent Item Name: Heli-Access-Step RH

Start Date: 9/20/2011

Required Date: 10/4/2011

Start Qty: 5.00

Required Qty: 5.00

NAS1515H3

Purchased

No

120

Each

136.0000

3

15



Washer



SP

Location

Loc Qty

Loc Code

ST277

136

116373

6

117460

8

118078

6

118384

116

NAS1515H4L

Purchased

No

120

Each

378.0000

24

120



WASHER



SEP 11-09-29

Location

Loc Qty

Loc Code

FG

12

103691

12

ST277

366

118709

366

120x

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Shop Packet Print

Page 4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-628

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5.2 D206-628-013/-014/-023/-024/-033/-034 FLOAT COMPATIBLE DART HELI-ACCESS-STEPS™ PARTS LIST

Qty -013	Qty -014	Qty -023	Qty -024	Qty -033	Qty -034	Part Number	Description
X						D206-628-013	206 A/B FLOAT STEP INST. LH
	X					D206-628-014	206 A/B FLOAT STEP INST. RH
		X				D206-628-023	206 L/L1/L3/L4 FLOAT STEP INST. LH
			X			D206-628-024	206 L/L1/L3/L4 FLOAT STEP INST. RH
				X		D206-628-033	407 FLOAT STEP INST. LH
					X	D206-628-034	407 FLOAT STEP INST. RH
				4	4	D2731-3	MOUNTING LUG
4	4	4	4			D2731-7	MOUNTING LUG
8	8	8	8	8	8	D2732-030	RUBBER CUSHION
1						D2841-041	FLOAT STEP ASSEMBLY LH
	1					D2841-042	FLOAT STEP ASSEMBLY RH
		1		1		D2842-041	FLOAT STEP ASSEMBLY LH
			1		1	D2842-042	FLOAT STEP ASSEMBLY RH
		2	2	2	2	D2844-1	ARM
		1	1	1	1	D2844-3	ARM
2	2					D2845	ARM
				4	4	D3394-041	MOUNTING LUG
				4	4	*D3394-1	*LUG
4	4			8	8	*MS35489-93	*GROMMET
4	4	4	4			D3394-043	MOUNTING LUG
4	4	4	4			*D3394-3	*LUG
8	8	8	8			*MS35489-93	*GROMMET
1	1					D4064-041	MOUNTING LUG
1	1					*D4064-1	*LUG
2	2					*MS35489-93	*GROMMET
2	2	3	3	3	3	AN3C4A	BOLT
4	4					AN4C13A	BOLT
4	4	4	4	8	8	AN4C14A	BOLT
4	4	8	8	4	4	AN4C15A	BOLT
2	2	3	3	3	3	NAS1149C0363R	WASHER (OR AN960C10)
16	16					NAS1149C0463R	WASHER (OR AN960C416)
8	8	24	24	24	24	NAS1149C0432R	WASHER (OR AN960C416L)
24	24	24	24	24	24	NAS1515H4L	WASHER
12	12	12	12	12	12	MS21043-4	NUT
2	2	3	3	3	3	NAS1515H3	WASHER

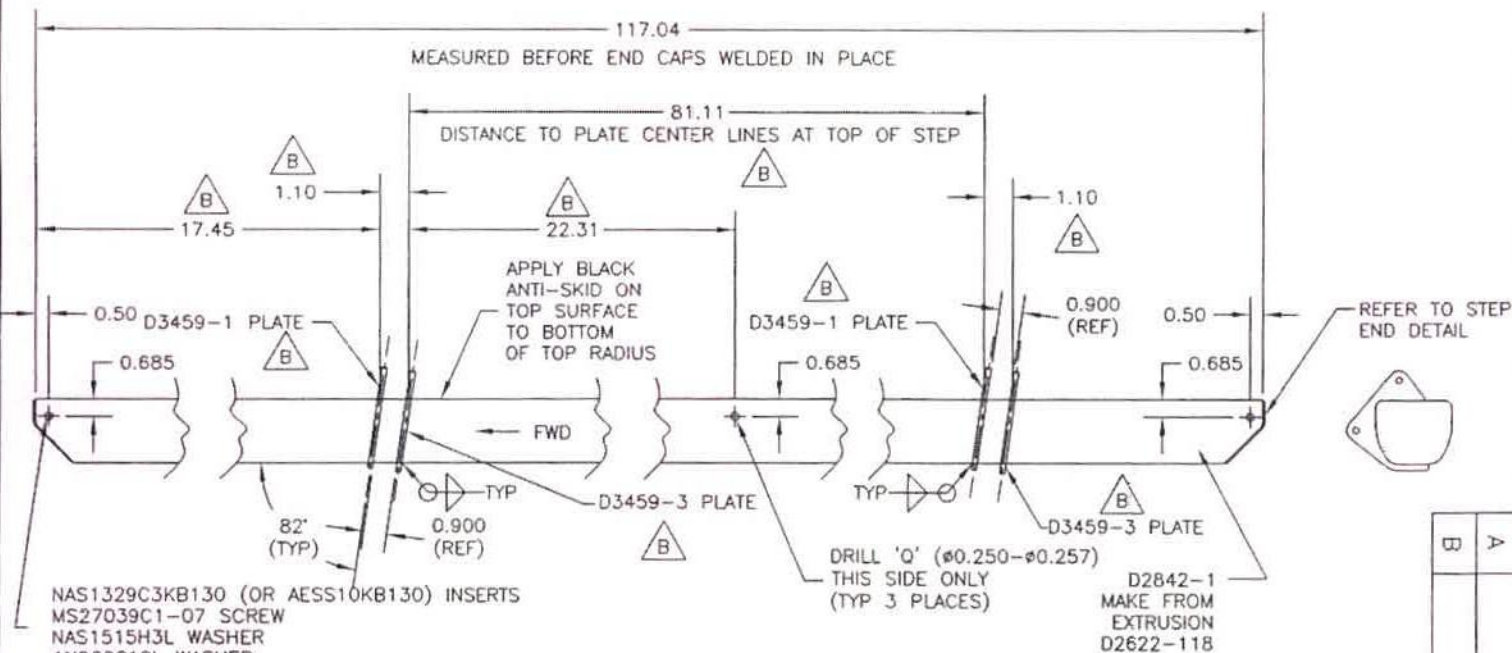
*DENOTES THAT PART IS INCLUDED IN ASSEMBLY ABOVE

5.3 QUICK RELEASE PIP PIN KIT

Qty -011	Part Number	Description
X	DSI9235-011	QUICK RELEASE PIP PIN KIT
4	BLRS-020	QUICK RELEASE PIN

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Revision: G
Date: 11.02.25

DART

NAS1329C3KB130 (OR AESS10KB130) INSERTS
MS27039C1-07 SCREW
NAS1515H3L WASHER
AN960C10L WASHER
(TYP 3 PLACES)

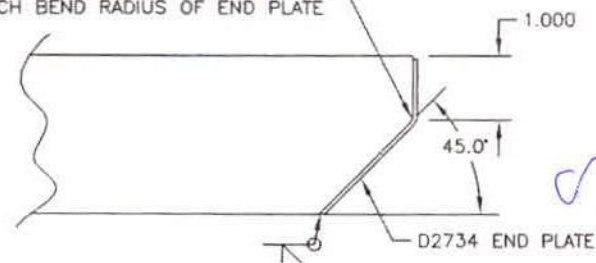
D2842-041 LH STEP ASSEMBLY (SHOWN)
D2842-042 RH STEP ASSEMBLY (OPPOSITE)

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004

D2842-041/-042 FLOAT STEP ASSEMBLY PARTS LIST

QTY - 041	QTY - 042	PART NUMBER	DESCRIPTION
X		D2842-041	LH STEP ASSEMBLY
	X	D2842-042	RH STEP ASSEMBLY
1	1	D2622-118	EXTRUSION
2	2	D2734	END PLATE
2	2	D3459-1	PLATE
2	2	D3459-3	PLATE
3	3	NAS1329C3KB130 (OR AESS10KB130)	INSERT
3	3	MS27039C1-07	SCREW
3	3	NAS1515H3L	WASHER
3	3	AN960C10L	WASHER

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2842-041/-042 FLOAT STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

REFERENCE ONLY

DESIGN	KE	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED		APPROVED		PORT HADLOCK, WA
DATE	05.09.23			DRAWING NO. D2842
	A	98.10.13		RE-DESIGN, ADD D3459-1/-3
	B	05.09.23		NEW ISSUE
				206L/407 FLOAT STEP ASSEMBLY
				SHEET 1 OF 1
				SCALE NTS

RELEASED

05.11.14